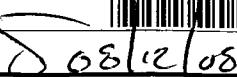
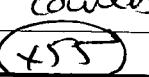
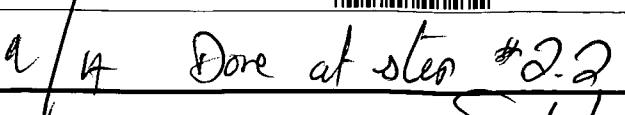
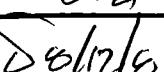


Date: Thursday, 27/11/2008 2:23:35 PM
User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	43802		
Estimate Number	10313		
P.O. Number	:	Part Number	: D26483
This Issue	27/11/2008	Drawing Number	: D2648 REV D
Prsht Rev.	NC	Project Number	: N/A
First Issue	11	Drawing Revision	: D
Previous Run	42770	Material	:
Written By	:	Due Date	: 10/12/2008
Checked & Approved By	JW 08.11.27	Qty:	50
Comment	Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM	Um:	Each
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S16GA	1010/1025 sheet 16GA 	
Comment: Qty.: 0.0788 sf(s)/Unit Total: 3.9375 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: 105706 1B 8-12-8			
2.0	WATER JET	FLOW WATER JET 	
Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: <u>D</u> 1B 8-12-8 Prog Rev: <u>D</u> 			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
2-Deburr if necessary 1B 8-12-8			
4.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK  counter 			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary  			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:35 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 43802

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 08/12/11

55

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R560Hardcoat M109560

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

EL 8-12-15

55

8.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/12/15

55

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15

55

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:50

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:20

m-1 08/12/15

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/12/15

55

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

Fx 08/12/15

55

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:35 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 43802

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/14 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43802
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648	Rev: D	Page 1 of 1

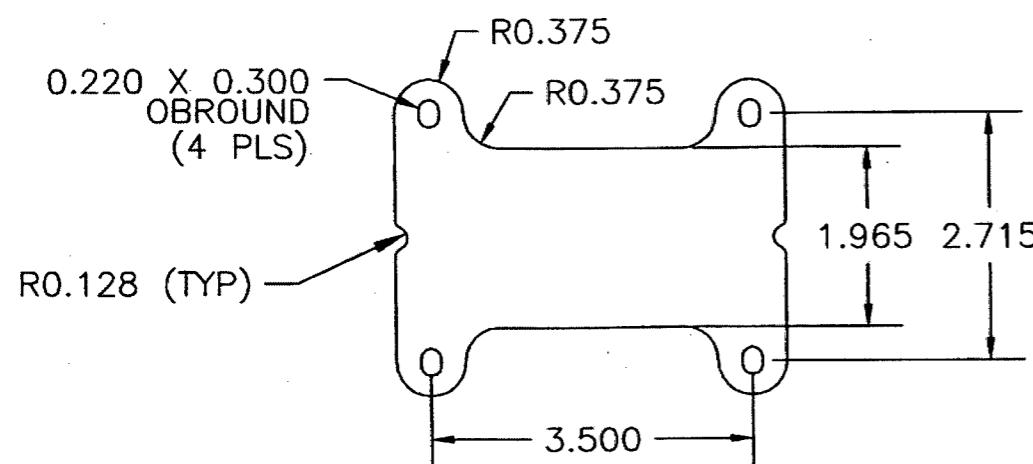
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

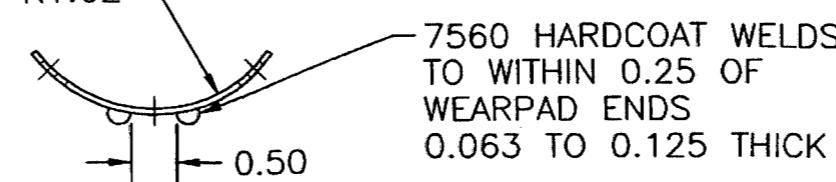
Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	8-17-08	Date:	08/17/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	<i>[Signature]</i>

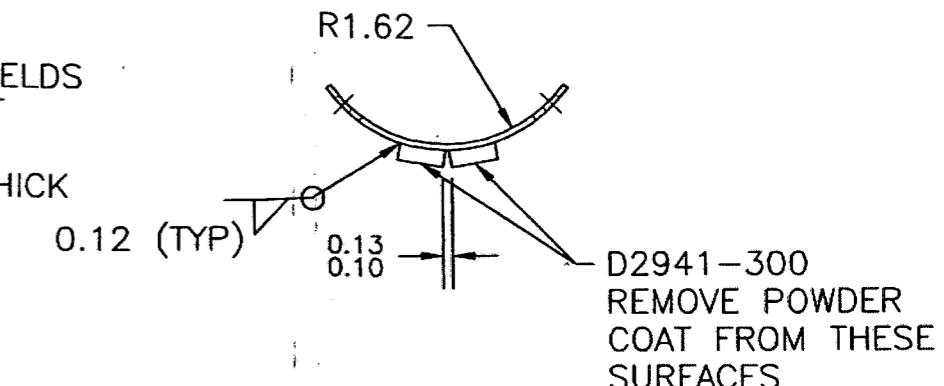
D2648-1 FLAT PATTERN



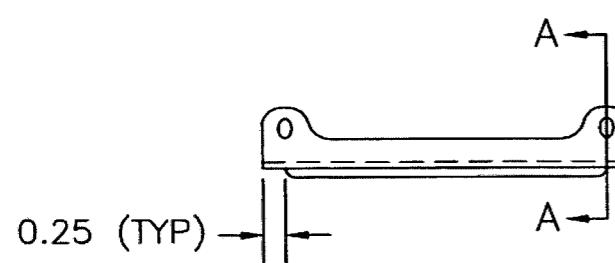
SECTION A-A



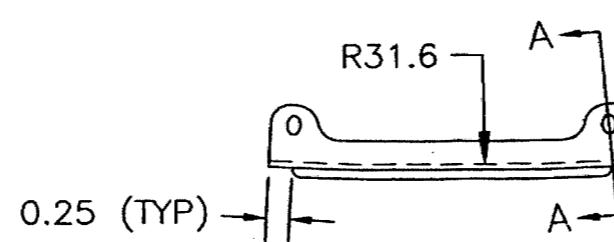
SECTION B-B



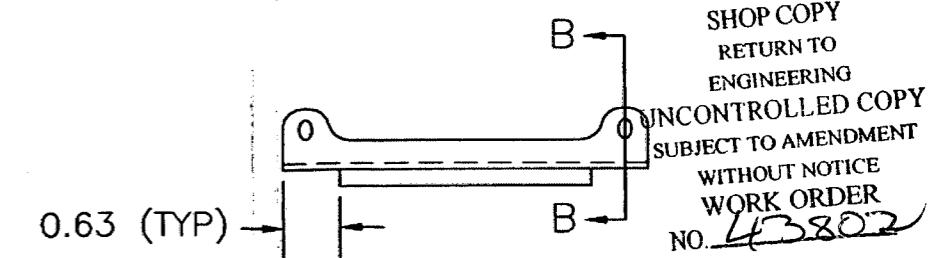
D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE		REV. D SHEET 1 OF 1 SCALE 1:2
		TITLE WEARPAD

RELEASED
98.12.20 DS

5
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